Work Orde				*902	201*							Page 1
Item ID: Revision ID:	D350-636-0	11		Accept	*N900	040	100	)*	Setup	Start	1.71	S1*
Item Name:	Skidtube LH									Stop	*N	S2*
Start Date:	9/26/12	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	10/05/12	<b>Req'd Qty:</b> 1.00	*1*		Customer:							
Reference:			-								•	
Approvals:	Process Pla	in: MLJ	Date: \2-09-\	7 Tooling:	Da	ite:			Run	Start	*N	R1*
		, –		<b>SPC (Y/N):</b>		ite:				Stop	*N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D2750	F											
100				0.00	6			7	1	<u> </u>		
*100*		DOCUMENT CONTRO	OL.	10	2/10/16			4	*+<1	HM	KJ 1	12-10-
DC		Memo		0.00	3/				7	•		
Document Control		Photocopy l	olue file and type labels pe	er PPP D350-636-011 CF	IG 006			Ū				

Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	eering uality
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	- <del></del>
Work Order:	- <del></del>
	- <del></del>
	- <del></del>
	Other
NCR No. Work Order Update Large Fab Composite Supplier	
Root Description of work order update Initial Action Sign &	
	nspector
Doc/Data Doc/Data	
Equip/Tooling	
Operator Department of the Control o	
Material	
Setup	
Other	
Process	
Supplier	
raining	
Unapproved	
FAULT CATEGORY  Landing Gear General	
Bending Bend Grain Ovalized Pressure	/Forced
	ture/Cure
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld	ture, cure
	tock Pulled
Cuffs Contamination Maintenance Part Moved	
Heat Treat Countersink Mislabeled Positioned Wrong	
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other	
Ripples in Bend Drill Holes Offset	
Torque Waves in Extrusion Drawing Out of Calibration	

Out of Sequence

Outside Dimensions

Date: • • •

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID:	D350-636-0	11		Accept	*N900	040	100	<b>)</b> * 9	Setup	Start	**	C1*
Revision ID:					NMI	11 141 1	, , , ,,	1	•		IV	20 I
Item Name:	Skidtube LH									Stop	*N	S2*
Start Date:	9/26/12	Start Qty: 1.00	*1	*	Cust Item I	D:						
Required Date:	10/05/12	Req'd Qty: 1.00	*1	*	<b>Customer:</b>							
Reference:								т	Run	Start		
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:		Г	Kun		*N	R1*
	QC:		<b>.</b>		D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID	<b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	ject y	Reject Number	Insp. Stamp
		Skidtubes		0.00								
* 1 1 ( ) * Skidtubes		Memo		0.00								
Skidtubes			2600-3 Bent									
			FWD and AFT ends, red dwg D2750	remove bending marks. Scribe bat	tch# inside							
		3- Drill pil deburr.	ot holes for blade fitti	ng bolt holes using DT8983. Ope	n to 0.500",							
		4- Locate I fitting	DT8330 off of blade fi	itting bolt holes and drill pilot hol	es for blade							
		5- Drill on	ly two fwd step holes	using DT9616. Ensure proper pos	sitioning.							
				02750 sheet 4 (D2750-1 details). E at side only DT8863B for second			A	) in 1	/	126	,	
			DT8863B on second s ND SIDE***	side of tube and drill pilot holes fo	or detail B.	\	t	3 121	Οţ		3	
		location he	oles to 0.500" (total of	0.375" (4 holes per side)and blad 4 holes per side) as per dwg D27 etail C to 0.500" (8 holes per side	50 .Open up					,		
		9-Drill pile	ot holes for wearplates	as per Dwg D2750 using DT810	8 open to							

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

										DQA:	Dat	e: _	1 4
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		QA Closed:	Dat	٠٥٠	•
							T					.е.	
Work Orde	ır.				DISPOSITION			AGAIN:	ST DE	PARTMENT	/PROCESS		
	<del></del>				Rework	]	•	Skid-tube Crosstul			Water Jet	$\Box$	Engineering
Part N	0				Scrap		1	Machining Small Fa		4	d. Eng. Coor.	$\dashv$	Quality Other
NCR N	lo				Use-as-is Work Order Update	_		noforming Finishii Large Fab Composi	~ <del> </del>	Rec/Sto	re/Packaging Supplier		Other
Root				Descri	ption of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty	c	or Non-conformance	Ch	nief Eng	Description		Date	, Verification	1	QC Inspector
Doc/Data										2			
quip/Tooling													
Operator												i	
Material													
Setup								·					
Other						1							
Process												ŀ	
Supplier										i.			
Training						İ							
Unapproved													
					F	AUL	LT CATE	GORY					
Landin	g Gear				General				_	<b>-</b>	,		
	Bending				Bend		Grain			Ovalized			Pressure/Forced
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance		Temperature/Cure
•	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ct	Ш	Weld
	Crushed/	Crimped,			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled
Γ	Cuffs				Contamination		Mainte	nance		Part Moved			
Ī	Heat Trea	it			Countersink		Mislabe	led		Positioned \	Vrong		
Γ	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	'Surge		Other
Ī	Ripples in	Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Ord September-13-1				*90	)201*						Page 3
Item ID: Revision ID:	D350-636-0	11		Accept	*N900	040	100	)*	Setup Sta	i Vi	S1*
Item Name:	Skidtube LH								Sit	<sup>ν</sup> *Ν	S2*
Start Date:	9/26/12	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	: 10/05/12	<b>Req'd Qty:</b> 1.00	*1*		Customer:						
Reference:			•	•							
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		J	Run Sta	1/1	R1*
					D	ate:			Sto	<sup>pp</sup> *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hour	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
		C 1 1'	2744 Cap as per Dwg D27: ng as per QSI 004 ninum Rod batch:	-	grooves in bend left  BE 12/09/27						
		12-Grind w	elds flush as per Dwg D27	50	B 12/59/27						
120		QC10- Inspect visual pe	r QS1004- ground welds	0.00 AS	•						•
*120*				16	17/07/27						
QC Quality Control		Memo		0.00							
130		QC5- Inspect part compl	leteness to step on W/O	0.00	12/01/27						
*130*			•	19.	<b>6</b> (2(2), 2)						
QC	•	Memo		0.00							
Quality Control											

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE			* /.
										QA Closed:	Date	<u>:</u>
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIGE	····	<del></del>			Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo				Scrap	]		Machining	Small Fab	4	d. Eng. Coor.	Quality
					Use-as-is		1	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		nitial		tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup	_											
Other	_											
Process						l						
Supplier												
Training	_			. *								
Unapproved				· · · · · · · · · · · · · · · · · · ·		<u> </u>						<u> </u>
						AUL	T CATE	JORY				
Landir	ng Gear			Γ	<b>General</b> Bend		Grain			Ovalized	Г	Pressure/Forced
}	Bending	- <b>+</b> Camaan		_/s	BOM/Route	-	Hardwa		-	Over/Under	tolorance	Temperature/Cure
	Centre No	ot Concer	יונווכ נסי	U/3	Broken/Damaged	$\vdash$		on Incomplete	-	Part Incorre	F-	Weld
ŀ	Cracks Crushed/	Crimonad		-		-		on incomplete/ ions incomplete/	Lincloar	Part Lost/M	<del>}</del>	Wrong Stock Pulled
ŀ	Cuffs	crimpeu.		-	Burrs Contamination	$\vdash$	Mainte	·	Officieal	Part Moved	issing _	
}	Heat Trea	.+			Countersink	$\vdash$	Mislabe		<del> </del>	Positioned V	Vrong	
ŀ	Inspection		Tubo	<u> </u>	Cut Too Short	-	Misread		<del> -</del>	Power Loss/		Other
}	Ripples in	•	iube		Drill Holes		Offset	I	<b>L</b>	Ti ower rossy	Juige [	Totalei
}	Torque W		vtrucio	<u>,</u> –	Drawing	$\vdash$		Calibration				
	Troudue W	aves III C		1	Iniaming	1	Journing	andiation				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 4

September-13-12 2:56:20 PM D350-636-011 Accept \*N900040100\* Setup Start Item ID: **Revision ID:** Stop Skidtube LH Item Name: Start Qty: 1.00 9/26/12 **Start Date: Cust Item ID:** Required Date: 10/05/12 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Date: **Approvals:** Stop Date: \_\_\_\_\_ SPC (Y/N): Date:\_\_\_\_ Accept Reject Reject Sequence ID/ Operation Tool ID Tool # Plan Insp. Set Up/ Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Chemical Conversion Coat per QSI005 4.1 0.00 140 76 12-9-27 \*140\* 0.00 HandFinish Memo Hand Finishing 150 QC7-Inspect Chemical Conversion Coat 0.00

\*150\*

QC

Memo

0.00

Quality Control

NCR: Y	es / No	)			WORK ORDER NON-	COI	NFORM	лANCE / UPI	DATE		•	• .
										QA Closed:	Date	<u> </u>
Work Orde	er:				DISPOSITION		:		AGAINST DI	EPARTMENT,	/PROCESS	
Part N	lo				Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			. <u></u>	Work Order Update			Large Fab	Composite	] 	Supplier	
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance :	Cr	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data								ł			i	
Equip/Tooling								i				
Operator												
Material			İ			1						
Setup				!								
Other								ĺ				
Process						.					-	
Supplier												
Training												
Unapproved		l	<u> </u>									
· · · · · · · · · · · · · · · · · · ·	<u> </u>			•	F	AUI	T CATE	GORY				<del> </del>
Landin	ng Gear			·	General				_	_	<u></u>	7
	Bendin	3			Bend		Grain			Ovalized	_	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	•	_	Over/Under	<b> -</b> -	Temperature/Cure
·	Cracks				Broken/Damaged		- 1	on incomplete		Part Incorred	<b>⊢</b>	Weld
	<del></del>	d/Crimped	-		Burrs		4	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ļ	Cuffs				Contamination		Mainte			Part Moved		
	Heat Tr	eat			Countersink	<u></u>	Mislabe		<u> </u>	Positioned V		¬ ·
Ĺ	Inspect	ion Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					
	Torque	Waves in I	Extrusio	n	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date: \_\_\_ ' ,

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-13-12	2:56:20 PM	1										
Revision ID:	D350-636-01 Skidtube LH	1		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	9/26/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				S		
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
	<u> </u>	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160* Skidtubes		Memo		0.00								
*160* Skidtubes Skidtubes		1-Open up I side) as per dwg 2-Open up I as per dwg 3- Open flo 4-Chamfer (welding in: 5-Deburr ar 6- Prepare t 7-Bond wet A/R Sik	D2750.  holes of Detail B to 0.75 D2750.  at hole to 0.500" (4 per structions on sheet 8)  ad blow out all chips from the sheet shee	ound handling and float holes m inside of tube e alodine as required.	per dwg D2750  DC 12/09/2			J	),;	2 ~	9- 2	27.
		(welding in A/R Alum	structions on sheet 8) inum Rod batch:  n AJ-AJ drill out x-bolt	11122399 spacer to 0.404"	3E 12/0/01							
w.**		10 Crind w	alde fluck as nor Duca D	2750	100							

NCR: Y	·												
	•									QA Closed:	Date	·	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier		
Root				Descri	ption of work order update		Initial	Actio	on	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Descrip	otion	Date	Verification	QC Inspector	
Doc/Data											i		
quip/Tooling							:						
Operator						}							
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
					F	AUI	T CATE	GORY					
Landir	ng Gear			-	General		,			7	<u></u>		
	Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re	<u></u>	Over/Under	<del></del>	Temperature/Cure	
,	Cracks				Broken/Damaged		4 '	on Incomplete	_	Part Incorre	<del>-</del>	Weld	
•	Crushed/	Crimped			Burrs		4	ions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	·	<b>-</b>	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	ł		Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes		Offset						
ſ	Torque W	aves in E	xtrusio	n [	Drawing		Out of C	Calibration					

Out of Sequence

Outside Dimensions

Date: \_\_\_\_\_

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-13-12				*902	?∩1*							Page 6
Item ID: Revision ID: Item Name: Start Date: Required Date:	D350-636-01 Skidtube LH 9/26/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900  Cust Item I Customer:		100	<b>)</b> *	Setup	Start Stop	I VI	S1* S2*
Reference:			~1~		Customer.			ı	Run	Start	.L.B. 1	<b>D</b> 4 ±
Approvals:		in:				ate:		•	Xuii	Stop	*N	R1* R2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description 11-Spot face dwg D2750		Set Up/ Run Hours ction (total of 4 places po	Tool ID er side) as per	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
170 *170* QC Quality Control		QC10- Inspect visual pe	r QS1004- ground welds	0.00 AS 16	17/10/02					*****		·

180

QC5- Inspect part completeness to step on W/O

\*180\*

Memo

Quality Control

											DQA:	Date	·
NCR:	Yes ,	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UPDATE		•		
											QA Closed:	Date	:
Work Ord	or:					DISPOSITION			AGAINST	r DE	PARTMENT/	PROCESS	
Part I	_				<del></del>	Rework Scrap			Skid-tube Crosstube Machining Small Fak		Prod	Water Jet	Engineering Quality
NCR I	_					Use-as-is Work Order Update			noforming Finishing Large Fab Composite	_	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	ption of work order update	- 1	Initial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material							1						
Setup							l		·				
Other						•							
Process							l						
Supplier		,											
Training										i			
Unapproved													
		<u>-</u>				F/	AUL	T CATE	GORY				
Landi	ng Ge	ar				General		•		_	,	<b></b>	
	<u></u> В∙	ending				Bend		Grain			Ovalized		Pressure/Forced
		entre No	t Concer	tric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
,	C	racks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	it	Weld
	[]cı	rushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	C	uffs				Contamination		Mainte	enance		Part Moved		
	Пн	eat Trea	t			Countersink		Mislabe	eled		Positioned V	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde			-	*90201*								
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	11		Accept	*N9000401	<b>೧</b> ೧*	Setup	Start Stop	*N.9	S1* S2*		
Start Date: Required Date: Reference:	9/26/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:		in:			Date:Date:		Run	Start Stop	*NF	R1* R2*		
Sequence ID/ Work Center II	)	Operation Description Pressure Wash per QSI00	05 4.3	Set Up/ Run Hours	Tool ID Tool # PI	lan Accep ode Qty	ot Rej Qty		Reject Number	Insp. Stamp		
*100* HandFinish Hand Finishing		Memo		0.00 n 4.1.2.1 do not acid etch.				76	, <u>1</u>	10.2		
200 *200* Powdercoat Powder Coating	d	White Gloss(Ref:4.3.5.1)  Memo START TIM	per QSI005 4.3-Alum  1E:	0.00 0.00 =		· / X	9			My 12/10/		
W(2) *210* QC	878	FINISH TIM  QC3- Inspect Part Finish  Memo	11-40	0.00			_ X		<b>P</b>	<u>(2/10/0</u>		

Inspect for foreign object per QSI 024

Quality Control

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-C	100	NFORM	MANCE / UPD				•
										QA Closed:	Date:	
				·	DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Orde	er:				Bassauli .	1	Skid-tube Crosstube			i	Water Jet	Engineering
Dort N	do.				Rework Scrap		Skid-tube Crosstube Machining Small Fab			Pro	d. Eng. Coor.	Quality
Part N	vo				Use-as-is Thermoforming				Finishing	1	re/Packaging	Other
NCR N	NCR No. Work Order Update					Large Fab Composite Supplier						
		_										
Root				Descri	ption of work order update	Ī	nitial	Actio	on	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator		1.										٠
Material												
Setup												
Other		İ		ľ								
Process		İ										
Supplier		1		ľ								
Training						l			•			
Unapproved						<u> </u>				<u> </u>		<u> </u>
	·					AUL	T CATE	GORY				
Landi	ng Gear			r	General		1		r	1		1
	Bending				Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
		ot Conce	ntric to	o/s	BOM/Route	_	Hardwa		-	Over/Under	<del>-</del>	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	igspace	1 '	on Incomplete	<u> </u>	Part Incorre	<del></del>	Weld
ļ		/Crimped	-		Burrs		1	ions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs Contamination						Maintenance			Part Moved			
Heat Treat Countersink						Mislabeled			Positioned Wrong		1	
Inspection Strip in Tube Cut Too Short					Misread Power Loss/Surge					Surge	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Work Order ID 90201 September-13-12 2:56:20 PM			*90201*									Page 8
Item ID: Revision ID: Item Name:	vision ID:			Accept	*N900	<b>040</b>	100	> Setup Start Stop			*N.	S1* S2*
Start Date: Required Date: Reference:	9/26/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
Approvals:		n:		Tooling: SPC (Y/N):		ite:		I		Start Stop	*NI *NI	२1* २2*
Sequence ID/ Work Center II 220 *20 * HandFinish Hand Finishing	)	Operation Description HandFinishing Memo 1- Install ins	erts as per Dwg D2750	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp 12/10/04
230 *730* HandFinish Hand Finishing		HandFinishing  Memo 1-Inspect for	· Foreign Objects	0.00				<u> </u>	¥	<u> </u>	<u>@</u>	12/10/05
		3-Install blad per dwg D27 SIKA FLEX BATCH:	241		ng hardware as							

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 121651

5-Coat all exposed fasteners with "LPS Procyon" batch: 14596

										DQA:	Date:	
NCR:	Yes / No				<b>WORK ORDER NON-</b>	COI	NFOR	MANCE / UPDATE		•		
										QA Closed:	Date:	
Marile Ond					DISPOSITION			AGAINS	ST DE	PARTMENT/	PROCESS	
Work Orde	er:				Rework	٦		Skid-tube Crosstub	٦,	1	Water Jet	Engineering
Part N	Jo.				Scrap	$\dashv$	1	Machining Small Fa		Pro	d. Eng. Coor.	Quality
raici	•0.				Use-as-is	1	1	noforming Finishir	<del></del>	4	e/Packaging	Other
NCR N	No.							~ <del>  </del>	~	,,,,,,,,,	Supplier	1
					· L.							
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data						ŀ						
Equip/Tooling												
Operator											•	
Material								,				
Setup												
Other												
Process												
Supplier						ŀ						
Training											•	
Unapproved		<u> </u>		<u> </u>			T CATE	CORV				<u> </u>
Landi	ng Gear				General	AUI	LICATE	JUNI				
Lanui	Bending				Bend		Grain			Ovalized		Pressure/Forced
		nt Concer	ntric to		BOM/Route	-	Hardwa	rο	<u> </u>	Over/Under	tolerance	Temperature/Cure
Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged			$\vdash$	1	on Incomplete	-	Part Incorred	<del> </del>	Weld			
Crushed/Crimped. Burrs			-	4	ions Incomplete/Unclear	-	Part Lost/Mi	<del></del>	Wrong Stock Pulled			
Cuffs Contamination					-	Mainte	•	<u> </u>	Part Moved		7 2.18 2.22 2116.2	
ļ	Heat Treat Countersink					Mislabe			Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

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Work Orde September-13-12				*902			Page				
Revision ID:	D350-636-01 Skidtube LH	1,1		Accept	)*	Setup Sta	1 72	S1* S2*			
	9/26/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	<b>)</b> :					
Approvals:		n:	Date:	Tooling: SPC (Y/N):	Da	te:		]	Run Sta Sta	1/7	R1* R2*
Sequence ID/ Work Center II 240 *740* QC Quality Control		Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours  0.00  0,000  D.OO	Tool ID	) 2/10/11		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 *250* Packaging Packaging		Pick Kit Memo		0.00					/45/1;	//5	

260

\*260\* QC Quality Control QC4- 100% Inspect kits for completeness

\*\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*\*

			DQA:	Date:	<u> </u>
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date:	
Work Orde	r·		·	• •	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &	<del></del>	T
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
	<b>!</b>				F	AULT CATE	GORY		<u> </u>		· • · · · · · · · · · · · · · · · · · ·
Landin	g Gear				General				_		_
	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning So	Crimped. t n Strip in Bend aves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete tions Incomplete enance eled		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
<u> </u>	Wave/Tw		e	<u> </u>	Folio	$\vdash$	e Dimensions	,			

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Work Ord				*					Page 10				
Item ID: Revision ID:	D350-636-01	11		Accept	*	N900	040	1100	)*	Setup	Start	*N	S1*
Item Name:	Skidtube LH										Stop	*N	S2*
Start Date:	9/26/12	Start Qty: 1.00	*1*		Cust Item ID:								
Required Date:	10/05/12	<b>Req'd Qty:</b> 1.00	*1*			Customer:							
Reference:										_	C44		_
Approvals:	Process Pla	n:	Date:	Tooling		D	ate:			Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y	/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	<b>D</b>	Operation Description	······································	Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accep Qty	ot Re	•	Reject Number	Insp. Stamp
270				0.00	2005				_				$\wedge$
*270*		Packaging			<b>X</b> 403				\$			12/10/	16 5
Packaging		Memo		0.00	hoc 72	-			ie.	7			,
Packaging		Package as	per PPP D350-636-011										
280		QC21- Final Inspection	- Work Order Release	0.00						J	$\sim 1$	الم	$\sim 1$
*280*									v=	/	1 A 11	011	0
QC		Memo		0.00									

Quality Control

Ø12-10-11

										DQA:	Date:	·
NCR:	res / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE				•
										QA Closed:	Date:	
					DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS	<i>,</i> ·
Work Orde	er:				Danie de la	٦		Skid-tube Crosstub		1	Water Jet	Engineering
Dowt N	ام				Rework Scrap	╡		Machining Small Fa	<u> </u>	Pro	d. Eng. Coor.	Quality
Part N	NO				Use-as-is	┨		noforming Finishir	-	4	e/Packaging	Other
NCR N	ماد				Work Order Update	$\dashv$	1	Large Fab Composit		1100,500	Supplier	Je
TTCIT I					Work Order opdate	J		zarge raa oompoon				· · · · · · · · · · · · · · · · · · ·
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												-
Material												
Setup						١٠	*					
Other												
Process					٠							
Supplier												
Training												
Unapproved												
					F	AUI	LT CATE	GORY				·
Landi	ng Gear			_	General	_	,			7		
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	$\perp$	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	L	Mainte	nance	L	Part Moved		
Heat Treat Countersink					Mislabe	led	Positioned Wrong					

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

90201

Parent Item:

D350-636-011

Parent Item Name:

Skidtube LH

**Start Date:** 9/26/12

Required Date: 10/05/12

Page 1

Start Qty: 1.00

Required Oty: 1.00

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ IPP Rev:J 06-03-23 As per Rev D JLM IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD IPP Rev:P 10.06.22 revise seq110 DD

verf:EC verf:EC

IPP Rev:Q 10.10.01 as per IIN revH DD verf:EC

86865 🗸

Qty per Kit Total Component Item ID/ Replacement Last Unit of Qty on Qty Date Status Mfg/ Bin Primary Route Measure Hand Item Name Location Issued Issued Item ID Seq ID Qty Purch Item Location D3492-1 No 230 Each 29.0000 Manufactured Plug Location Loc Qty Loc Code 90334 FP002 22 69531 74444 76235 88541 FP-A 83098 D3492-3 No 230 Each 123.0000 12/16/03 Manufactured Plug Loc Qty Loc Code Location FP-A 123 81967 5 3 83099 83529 46 9 85461

60

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-O	100	NFORN	MANCE / UPDA		QA Closed:	Date:	
Work Orde	<b></b>				DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
	No				Scrap Machining Small Use-as-is Thermoforming Finis			Crosstube Small Fab Finishing omposite	Pro Rec/Stoi	Engineering Quality Other		
Root				Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
Unapproved	!	<u> </u>	L		F	AUL	T CATE	GORY			<u> </u>	
Landir	ng Gear				General							
Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unck nance led	ear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Torque W	aves in E	xtrusio	า [	Drawing	ing Out of Calibration						

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

. September-13-12 2:56:19 PM

Work Order ID:

90201

Parent Item:

NAS1611-010

O-RING

D2744

Cap

D350-636-011

Parent Item Name:

Skidtube LH

Purchased

Manufactured

No

No

**Start Date: 9/26/12** 

Required Date: 10/05/12

Start Qty: 1.00 Required Qty: 1.00

120308

NAS1149D0863J	Purchased	No	250	Each	163.0000	2	2
WASHER						10111111111111111111111111111111111111	
		<b>Location</b>	Loc Qty		Loc Code		

85506

<u>Location</u>	Loc Qty
ST298	163
118078	28
119307	1
120308	34
121556	100
	220

160.0000 Each 230

12/10/03

Location	Loc Qty	Loc Code
FP001	160	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
121259	2	
121584	2	
121723	7	
122151	76	

Loc Qty Location Loc Code LG002 37 62715 1

110

Each

36

37.0000

NCR:	Yes / I	lo			WORK ORDER NON-O	OI	NFOR	MANCE / UPDAT		QA Closed:	Date	•
					DISPOSITION			Α	AGAINST DEI			
Work Orde	er:				Rework			Skid-tube Cr	osstube		Water Jet	Engineering
Part N	No				Scrap Use-as-is		1	<b>~⊢</b> ⊣	mall Fab Finishing		d. Eng. Coor. re/Packaging	Quality Other
NCR I	No				Work Order Update	]		~ <del></del>	mposite	Nee/ Stor	Supplier	
Root				1	ption of work order update	ı	Initial	Action		Sign &		
Cause	Da	e Ste	o Qty	(	or Non-conformance	Ch	nief Eng	Descriptio	n	Date	Verification	QC Inspector
Doc/Data					•	1						
Equip/Tooling												
Operator												
Material											i	
Setup				1								
Other						l						
Process								-				
Supplier		1								·		
Training						]			•			
Unapproved	<u> </u>					<u> </u>						
						AUL	T CATE	GORY				
Landi	ng Gear				General		1			İ	_	<b>–</b>
	Bend	_			Bend	L_	Grain			Ovalized	-	Pressure/Forced
	Centr	e Not Con	centric to	O/S	BOM/Route		Hardwa		<u> </u>	Over/Under	-	Temperature/Cure
	Crack				Broken/Damaged		1	on Incomplete		Part Incorre	-	Weld
·		ed/Crimpe	ed.		Burrs	<u> </u>	4	ions Incomplete/Unclea	<del> </del>	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	L	Mainte			Part Moved		•
ļ	Heat	reat		ļ. 	Countersink		Mislabeled			Positioned V		<del></del>
	Inspe	ction Strip	in Tube		Cut Too Short			İ		Power Loss/	Surge	Other
	Ripple	es in Bend Drill Holes					Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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. September-13-12 2:56:19 PM

Work Order ID: Parent Item: Parent Item Name:	90201 D350-636-011 Skidtube LH							Date: 9/26/12 t Qty: 1.00	Required Date: 10/05/12 Required Qty: 1.00
D2600-3-BENT Extrusion Bent		Manufactured	No		110	Each	23.0000	J	B 12/09/26
			<u>Lo</u> LG	66875 73253 75021 75022 75023 81330	Loc Oty  23  7  1  1  4		Loc Code		
				83305 88712	7				
D2743 Crossbolt Spacer		Manufactured	No		160	Each	275.0000	8	8 BE12-10-01
			Lo	cation	Loc Qty		Loc Code		
			LG		201				
				81965	23				
				83262	2				
				85459	51				·····
				86896	3				
				88504	122				<del></del>
			LG	001	74				
				67766	4			<del></del>	
				68251	3				
				73403	64				<del>.</del>
				74445	1				<del></del>
				79517	2				

				•							DQA:	Date	
NCR:	es /	No				WORK ORDER NON-	COI	NFORN	ANCE / UPD		•		•
											QA Closed:	Date	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	·· —					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo	<del></del>				Scrap Use-as-is		ľ	Machining of orming	Small Fab Finishing	ł	d. Eng. Coor.	Quality Other
NCR N	lo					Work Order Update	}	i	Large Fab	Composite	Nec/3tol	Supplier	
Root					Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause	D	ate	Step	Qty	C	or Non-conformance	Ct	nief Eng	Descrij	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material						•							
Setup													
Other													
Process													
Supplier								i					
Training													
Unapproved					,		1		<i>i</i>		<u> </u>		
						F	AUI	LT CATE	GORÝ,				
Landir	ng Gear					General		_	•		•		_
	Ben	ding				Bend		Grain			Ovalized		Pressure/Forced
	Cen	tre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crad	ks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
[	Crus	hed/0	Crimped.			Burrs		Instructi	ons Incomplete/Ur	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuff	s				Contamination		Mainte	nance		Part Moved		
ſ	Hea	t Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	<b></b>
Ì	insp	ection	Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripp	les in	Bend			Drill Holes		Offset			=		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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## **Picklist Print**

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Work Order ID: Parent Item: Parent Item Name:	90201 D350-636-011 Skidtube LH			,				Date: 9/26/12 Qty: 1.00	Required Date: 10/05/12 Required Qty: 1.00
D2739		Manufactured	No	B90509	1 160	Each	6.0000	1	2/09/28
350 I Beam					5			DC 1	6/01/68
				Location	Loc Qty		Loc Code	<i>(</i> ')	•
				LG	6				
				72155	1				
				81508	1				
				85487	1				_
				86615	1				
				87734	2				<del>_</del>
D3490-3		Manufactured	No		160	Each	54.0000	4	4 8F12-10-01
Cross Bolt Spacer								0000-000-000-000-000-000-000-000-000-0	DT 12-10-01
				<u>Location</u>	Loc Oty		Loc Code		
				LG001	54				<del></del>
				85420	14			4_	<u> </u>
				86980	40				
D3490-1		Manufactured	No		160	Each	117.0000	4	4
Cross Bolt Spacer								Name of the last o	4 BE12-10-01
				Location	Loc Oty		Loc Code		
				LG	108				
				81976	2				
				86979	40			4	
				88617	66				_
				LG001	9				
				62450	2				
				74875	4			*****	
				77042	3				

Work Order:    Part No.	NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE .													
Note   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Step   Other   Part No.   Other   Part No.   Step   Other   Part No.   Part No.   Other   Part No.   P			,							<u>,                                      </u>		QA Closed	: Da	te:	•
Part No.	Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC In Doc/Data Equip/Tooling Operator		•					Scrap Use-as-is		Therm	Machining noforming	Small Fab Finishing		od. Eng. Coor. re/Packaging		Engineering Quality Other
Doc/Data Equip/Tooling Coperator Material Counterly Comments of Counterly Co	Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Equip/Tooling Operator Material Operator Materia	Cause		Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Landing Gear  Bending Bend Centre Not Concentric to O/S BOM/Route Broken/Damaged Crushed/Crimped Cuffs Cuffs Contamination Heat Treat Inspection Strip in Tube  General  Grain Ovalized Over/Under tolerance Hardware Inspection Incomplete Inspection Incomplete Instructions Incomplete/Unclear Maintenance Maintenance Mislabeled Power Loss/Surge Other	Equip/Tooling Operator Material Setup Other Process Supplier Training														
Bending Bend Grain Ovalized Pressure/ Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperat Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong St Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other	l and:		`			·		-AUI	LICATE	JURY	-				
Torque Waves in Extrusion Drawing Out of Calibration	Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped, it n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	'Unclear	Over/Unde Part Incorre Part Lost/M Part Moved Positioned	ect lissing l Wrong	Te W W	rong Stock Pulled

Out of Sequence

Outside Dimensions

Date: \_\_\_

DQA:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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. September-13-12 2:56:19 PM

Work Order ID: Parent Item:	90201 D350-636-011							Start D	eate: 9/26/12	Requ	ired Date: 10/05/12
Parent Item Name:	Skidtube LH							Start (	Qty: 1.00	Req	uired Qty: 1.00
ALS4-1032-225 Insert		Purchased	No		g pila de la centerio	220	Each	2,785.0000	38	38	12/10/03
				Location		Loc Oty		Loc Code			117
				FP-B		1346					
					122290	1346					
				ST281		1416					
					108696	146					
					110768	62					
					118386	55					
					118966	68					
					121269	85					
					122827	1000					
				ST282		23					
					120410	10			T-10-10-10-10-10-10-10-10-10-10-10-10-10-		
					120451	13					
D3793-3 Wearshoe		Manufactured	No			230	Each	18.0000	1	1 (P)	12/10/03
				Location		Loc Qty		Loc Code			• •
				FP001		18					
					83394 🗸	2					1
					83901	4					
					87135	12					\
AN8C35A		Purchased	No			230	Each	30.0000	1	100	/ /
BOLT		1 41 4143 44								(P)	12/10/03
				Location	<u>.</u>	Loc Qty		Loc Code			' /
				FP002		29					
					115960	1					
					121275	28					
				ST346		1					
					114442	0			****		
					115188	0		4			
					115960	1					

NCR:	Yes / No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE		•			•
								-		QA Clo	osed:	Date	2:	_
Work Orde	or.				DISPOSITION				AGAINST D	EPARTN	/ENT	/PROCESS		
WOIK OIG					Rework	1		Skid-tube	Crosstube	7		Water Jet	Engineering	
Part N	No.				Scrap	1	1	Machining	Small Fab		Pro	d. Eng. Coor.	Quality	
					Use-as-is	1	Therm	noforming	Finishing	Red	c/Stor	re/Packaging	Other	
NCR N	No			<del></del>	Work Order Update	]		Large Fab	Composite			Supplier		
Root				Descri	ption of work order update		Initial	Act	ion	Sign	1 &			-
Cause	Date	Step	Qty	Ć	or Non-conformance	Ch	nief Eng	Descr	ription	Da	te	Verification	QC Inspector	
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved										<u> </u>				_
, , , ,					F	AUL	T CATE	GORY						_
Landir	ng Gear				General				-	_		_	_	
	Bending				Bend		Grain			Ovalize	ed		Pressure/Forced	
]	Centre No	ot Concer	ntric to C	)/s	BOM/Route		Hardwa	re		Over/۱	Jnder	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part In	corre	ct _	Weld	
·	Crushed/0	Crimped.			Burrs		Instructi	ions Incomplete/U	Jnclear	Part Lo	ost/Mi	issing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance		Part M	loved		4	
	Heat Trea	t			Countersink		Mislabe	led		Positio	ned V	Vrong	<del></del>	
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power	Loss/	Surge	Other	_
ſ	Ripples in Bend				Drill Holes Offset									

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-13-12 2:56:19 PM

230 Each	<b>Start Date:</b> 9/26/12 <b>Start Qty:</b> 1.00	Required Date: 10/05/12 Required Qty: 1.00
. *	•	Required Oty: 1.00
Each		
	15.0000 1	1000 12/10/03
Loc Oty	Loc Code	, ,
15		
2		
1		
12		
Each	11.0000 1	100 12/10/03
Loc Oty	Loc Code	- , , ,
3		
3		
8		
3		
5	<u> </u>	
Each Each	22.0000 1	(DP) 12/10/03
Loc Oty	Loc Code	
22		. •
20		
230 Each	116.0000 4	12/10/03
Loc Qty	Loc Code	
2		
2		<u> </u>
44		
44	<b>v</b>	
50	3	
50		
20		
11		
9		
	15 2 11 12 30 Each  Loc Oty  3 3 8 8 3 5 30 Each  Loc Oty  22 20 30 Each  Loc Oty  22 44 44 50 50 50 20 11	15 2 11 12 30 Each 11.0000 1 Loc Oty Loc Code  3 3 8 3 8 3 5 30 Each 22.0000 1 Loc Oty Loc Code  22 2 20 30 Each 116.0000 4 Loc Oty Loc Code  22 2 2 30 30 Each 116.0000 4  Loc Oty Loc Code  2 3 3 4 4 4 5 5 5 5 2 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1

										DQA:	Date:	
NCR: \	es / No				WORK ORDER NON-	cor	NFOR	MANCE / UPDATE		-		
	·									QA Closed:	Date:	
					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Work Orde	er:				D = = #L	ا ر		Skid-tube Crosstube		1	Water Jet	Engineering
Doub A	la.				Rework Scrap	+		Machining Small Fab	_	4	d. Eng. Coor.	Quality
Part N					Use-as-is	1 1		noforming Finishing	-	4	e/Packaging	Other
NCR N	lo				Work Order Update	1	Inem	Large Fab Composite		1100,3107	Supplier	"""
WCK 7					Work order opdate	ا لـ		zurge rub oomposite	_	J		J
Root				Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												t I
Operator												
Material												
Setup												
Other												
Process [			·									
Supplier												
Training												
Unapproved							,					
					F	AUL	T CATE	GORY				
Landir	ng Gear				General				_	7	_	1
	Bending			<u> </u>	Bend		Grain		$\perp$	Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorrec	it	Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
Ī	<del>-</del>				Countersink	Mislabeled				Positioned W	<b>/</b> rong	_

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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. September-13-12 2:56:19 PM

Work Order ID: Parent Item: Parent Item Name:	90201 D350-636-011 Skidtube LH							Date: 9/26/12 Qty: 1.00		red Date: 10/05/12 ired Qty: 1.00
<b>MS21083C8</b> NUT		urchased	No	×	230	Each	57.0000	I minutes and a second a second and a second and a second and a second and a second and a second and a second and a second and a second and a second a second and a second and a second and a second and a second and	50	12/10/03
				Location 318 12244)	<u>Loc Qty</u> 33		Loc Code			· / · ·
				122452	33				<u> </u>	
	4 2		}	FP002	1					
				115884	1			<u> </u>		
	<i>XX</i> '		:	ST303	4					
	73			115884	0					
				118077 119309	1			-		
				119638	2					
				ST321	19			****		
			•	122141	19			-	<del></del>	
<b>D3536-25</b> Gasket	M	anufactured	No	_	230 í	Each	18.0000	1		12/10/03
			j	Location	Loc Qty		Loc Code			1 1 -
			]	FP	7					
				83900	1					
				87053	6					
			]	FP002	11					
				89057	11				. <u></u>	
D3631-1 Washer	М	anufactured	No		230	Each	143.0000	<u>*</u>		12/10/03
			]	<b>Location</b>	Loc Oty		Loc Code			
			]	FG	28					
				81874	2					
				83588	26					
			]	FP-A	100					
				89277 🗸	100				<del></del>	
			:	ST072	15				_	
				68062 75548	2 13					
				13348	13				<del></del>	

										DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
NCR: Y	res / No				WORK ORDER NON-O	CON	NFORM	MANCE / UPDATE				
	•									QA Closed:	Date:	
NAV - ml : O mal a		-			DISPOSITION			AGAINS	ST DE	PARTMENT/	PROCESS	
Work Orde	er:				Rework	1 I		Skid-tube Crosstut	na[	1	Water Jet	Engineering
Part N	lo.				Scrap	1 I		Machining Small Fa	$\vdash$	Prod	d. Eng. Coor.	Quality
raitiv		<u></u>		<del></del>	Use-as-is	1		noforming Finishin	<u> </u>	l .	e/Packaging	Other
NCR N	lo.				Work Order Update	1		Large Fab Composi	~ <del>-</del>	,	Supplier	1 -
1001111						۱ ا			<b></b>		.,	
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description	,	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material			ļ									
Setup												
Other												
Process												
Supplier				ļ								
Training												
Unapproved		<u> </u>	1			<u> </u>						1
						AUL	T CATE	GORY				
Landin F	ng Gear				General	$\Box$	ر ما			ا - ا		Pressure/Forced
	Bending	_		_	Bend	$\vdash$	Grain		-	Ovalized	A - 1 - 1 - 1 - 1	-i
<u>.</u> •	Centre N	ot Concei	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		-	Over/Under		Temperature/Cure
}	Cracks			<u> </u>	Broken/Damaged	-	1	on Incomplete	-	Part Incorred	<del> </del>	Weld
}				Burrs	$\vdash$	i	ions Incomplete/Unclear	$\vdash$	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination	-	Mainte		-	Part Moved	f.,	
1	Heat Trea	Heat Treat			Countersink	1 1	Mislabe	rlea	- 1	Positioned V	vrong	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

. September-13-12 2:56:19 PM

Work Order ID:	90201								
Parent Item:	D350-636-011		•			Start	Date: 9/26/12	Requir	red Date: 10/05/12
Parent Item Name:	Skidtube LH					Start	<b>Qty:</b> 1.00	Requi	ired Qty: 1.00
D3791-1 Wearplate	Manufactured	No		230	Each	22.0000	1	50	12/0/03
Wearplace			<u>Location</u>	Loc Oty		Loc Code	•		
			FP001	19					
			87422	10					
	*		89244	9					
			FP002	3					
			62239	2					
			83392	1			W7780777047748074		
AN960C10L washer	NAS1149C0332R Purchased	No		230	Each	21.0000	38	38	(2/10/04.
			Location	Loc Oty		Loc Code			
			ST 123248/	21					
			107534	21					
D2745	Manufactured	No		230	Each	142.0000	8 0	8	
Bushing								Ø	- 12/10/03
			<b>Location</b>	Loc Oty		Loc Code			
			FP	138					
			79518	6				<u> </u>	
			85416	12					
			86870	40					
	·		87527	40				<del></del>	
			89303	40					
			FP001 69529	4					
			69529 76142	1					
			83260	2			<del></del>		
			00200	_			***************************************		

											DQA:	Date:		
NCR:	Yes ,	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE				
Work Order:								QA Closed:	Date:					
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
						Rework		Skid-tube Crosstube			Water Jet		Engineering	
Part No.						Scrap	]		Machining	Small Fab	4	d. Eng. Coor.	Quality	
NCR No.						Use-as-is Work Order Update	<u> </u>	l	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root			-		Descri	l ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty	-	or Non-conformance		ief Eng	Desc	Description		Verification	QC Inspector	
Doc/Data		- "							: :					
Equip/Tooling														
Operator														
Material	П													
Setup	П													
Other	П													
Process	П						ĺ							
Supplier														
Training														
Unapproved									-					
						F	AUL	T CATE	GORY					
Landi	ng Ge	ar	•			General					-		<b>-</b>	
Bending						Bend	Grain				Ovalized		Pressure/Forced	
Centre Not Concentric to O/S					7/5	BOM/Route	Hardware				Over/Under	tolerance	Temperature/Cure	

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

**Outside Dimensions** 

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

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September-13-12 2:56:19 PM

Work Order ID: 90201 **Start Date: 9/26/12** Required Date: 10/05/12 Parent Item: D350-636-011 Required Qty: 1.00 Start Qty: 1.00 Parent Item Name: Skidtube LH AN3C5A 230 No Each 1,277.0000 Purchased Bolt Loc Qty Loc Code Location 7 FP001 7 115835 ST350 1270 115835 0 116419 28 13 117343 117764 7 117872 2 119749 23 28 120423 121255 23 121708 500 122141 80 122800 566 230 Each 67.0000 D3537-1 No Manufactured 12/10/03 Wearpad Location Loc Qty Loc Code 67 83255 3 87697 37 26 88562 230 NAS1149C0832R No Each 419.0000 Purchased WASHER Loc Qty Loc Code Location 296 200 122441 200 ST297 219 114915 219

NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UP	DATE			
			_								QA Closed:	Date:	•
Work Ord	er: .					DISPOSITION	7				EPARTMENT/		1
Part I	•				<del></del>	Rework Scrap Use-as-is The Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
							_						-
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUI	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/0		ntric to (	o/s	General Bend BOM/Route Broken/Damaged Burrs		Instruct	on Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	et	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				Contamination Countersink Cut Too Short Drill Holes		Maintenance Mislabeled Misread Offset Out of Calibration		Part Moved Positioned W Power Loss/		Other			
	Torque Waves in Extrusion				' L	Drawing	L.	Jour of C	วสเเบเสนเบน				

Outside Dimensions

Date: \_\_\_\_

DQA:

Turning Sequence

Wave/Twist in Tube

Finish Folio September-13-12 2:56:19 PM

Work Order ID: Parent Item: AN3C6A BOLT

NAS1611-013

O-RING

90201

D350-636-011

Parent Item Name:

Skidtube LH

**Start Date: 9/26/12** 

Start Qty: 1.00

Required Date: 10/05/12

Required Qty: 1.00

Purchased	No	230	Each	1,139.0000	4	(2)	12/10/03
	Location	Log Oty	1	Loo Codo			

<u>Locati</u>	<u>on</u>	Loc Qty	Loc Code		
FP001		1			
	111982	1			
ST351		1138			
	111982	2			
	116419	23			
	116549	2			
	116704	12			
	117619	10		·	
	117688	1			
	117872	5			
	118422	13			
	119449	21			
	120423	3			
	120693	42			
	121682	4			
	122416	500			
	122599	500			
)		230 E	Each 228.0000	8 -8 - 8	12/10/03
				-	, = 1

Purchased

No

Location Loc Qty Loc Code FP001 228 116582 5 117291 2 53 117887 119623 36 121825 18 121826 🗸 14

100

122993

NCR: Y	es / No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			
	,									QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				<b>1 1 1 1 1 1 1</b>			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		Initial	Ac <sup>1</sup>	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material			1 1									
Setup												
Other			] [									
Process												
Supplier											į	
Training												
Unapproved						<u> </u>						
					F	AUI	LT CATE	GORY				
Landir	ng Gear				General	_	7			_	_	7
	Bending			<u> </u>	Bend	$\perp$	Grain		<u> </u>	Ovalized		Pressure/Forced
]	Centre No	ot Conce	ntric to (	)/S	BOM/Route		Hardwa	re		Over/Under		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	_	Part Incorre	<del></del>	Weld
	Crushed/	Crimped.		<u> </u>	Burrs	L	Instruct	ions Incomplete/I	Unclear	Part Lost/M	ssing	Wrong Stock Pulled
Ĺ	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V		7
Į	Inspectio	n Strip in	Tube		Cut Too Short	_	Misread	l		Power Loss/	Surge	Other
	Ripples in	Bend		L	Drill Holes		Offset					
		Drawing	Out of Calibration									

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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September-13-12 2:56:19 PM

Work Order ID: 90201 **Start Date: 9/26/12** Required Date: 10/05/12 D350-636-011 Parent Item: Required Qty: 1.00 Start Qty: 1.00 Parent Item Name: Skidtube LH D3535-25 230 20.0000 No Each Manufactured Wearshoe Loc Oty Loc Code Location FP001 20 62233 81357 83387 ~ 5 13 87385 D3794-1 No 230 Each 13.0000 Manufactured Gasket Loc Oty Location Loc Code FP 12 12 FP002 83395 MS21043-6 230 Each 466.0000 No Purchased NUT Loc Oty Location Loc Code FG 20 103693 20 ST301 446 117887 2 120308 444 D3493-1 Manufactured 250 41.0000 No Each Location Loc Qty Loc Code ST050 41 77573 1 82023 2 83057 83097 38

										DQA:	Date:	e
NCR:	Yes / No	)			WORK ORDER NON-	CO	NFORM	ANCE / UP	DATE		<del></del>	•
								·		QA Closed:	Date:	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK Olde					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	No.				Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			·	· ·	Use-as-is	]	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update			Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			'									
Operator												
Material												
Setup						1						
Other											İ	
Process			1 .									
Supplier												
Training			1									
Unapproved												
					F	AUI	LT CATE	GORY				
Landir	ng Gear				General		_		<u></u>	_		<b>-</b>
	Bendin	3			Bend		Grain			Ovalized		Pressure/Forced
*	Centre	Not Conce	ntric to (	)/S	BOM/Route		Hardwa	re	[	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	-		Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
Ī	Heat Tr	eat			Countersink		Mislabe	led		Positioned \	Vrong	_
Ī	Inspect	ion Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
Ì	Ripples in Bend			Drill Holes	Offset			_				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

. September-13-12 2:56:19 PM

Work Order ID: Parent Item: Parent Item Name:	90201 D350-636-011 Skidtube LH								Date: 9/26/12 Qty: 1.00		ired Date: 10 ابل iired Qty	
MS21083C8		Purchased	No			250	Each	57.0000	2	2 - 	<u>//</u>	3
O				Location		Loc Oty		Loc Code				
				318		33						
					122452	33			12240	52		
				FP002		1						
					115884	1						
				ST303		4			· · · · · · · · · · · · · · · · · · ·			
					115884	0						
					118077	1			-			
					119309	2				<del></del>		
					119638	I				wman		
				ST321		19				_		,
/					122141	19				<del></del>		
AN8C21A  BOLT		Purchased	No			250	Each	45.0000	2	2//	/ 1	
				Location		Loc Qty		Loc Code				
				ST341		25						,
					122519	25			12251	2		
				ST343		20						
					118758	1						
					122204	19				<u></u>		
NAS1515H3L WASHER		Purchased	No			230	Each	231.0000	4 4	400	12/1	0/04
WASHER				Location		Loc Qty		Loc Code			17	~
				FG		40						
					102472	40				*		
				ST277		191						
					118686	3			<del></del>	*****		
					120360	11						
					121556	45						
					122151	132						

NCR:	Yes / No				WORK ORDER NON-	COI	<b>NFORM</b>	MANCE / UPC	ATE			_
		_						-		QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
IVCK	NO				Work Order Opdate	J		Large Fab	Composite		20ppilei	
Root				Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material		-										
Setup				!		ł	,					
Other												
Process*	Ц											
Supplier												
Training												
Unapproved												
						AUL	LT CATE	GORY				
Landii	ng Gear				General		7		<b>_</b>	٦	г	٦ .
	Bending			_	Bend	_	Grain			Ovalized	<u> </u>	Pressure/Forced
	<del></del>	Not Conce	ntric to	o/s  _	BOM/Route	<u></u>	Hardwa			Over/Under	<del> </del>	Temperature/Cure
	Cracks				Broken/Damaged	_	4 '	ion Incomplete	<u> </u>	Part Incorred	<del> </del>	Weld
	<b></b>			Burrs	_	-	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			Contamination	_	Mainte		<u> </u>	Part Moved			
	Heat Tre			$\vdash$	Countersink		Mislabe		<u> </u>	Positioned V		<b>.</b>
ļ	_	on Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ripples in Bend Drill Holes			4	<u></u>	Offset						
	Torque Waves in Extrusion			Drawing	Out of Calibration							

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

. September-13-12 2:56:20 PM

Work Order ID:

90201

Parent Item:

D350-636-011

Parent Item Name:

Skidtube LH

D2741

Blade, 350 Skidtube

Manufactured

No

**Start Date:** 9/26/12

29.0000

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.09

		<b>Location</b>	Loc Qty		Loc Code
		ST	-10		
		ST466	39		
		71856	1		
		85480	28		
Manufactured	No		250	Each	26.0000

Loc Qty Loc Code Location ST056 26 26 85484

250

Each

NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDA <sup>-</sup>	TE			
	,							•		QA Closed:	Date	: 
Work Orde	er:				DISPOSITION				AGAINST DEF	PARTMENT	/PROCESS	
	Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	Prod Rec/Stor	Engineering Quality Other		
Root				Descri	l ption of work order update	1	Initial	Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling								1				
Operator												
Material												
Setup					•							
Other												
Process												
Supplier												
Training												
Unapproved		<u> </u>										
_					<u> </u>	AUL	T CATE	GORY				
Landir	ng Gear				General		,				_	<del>_</del>
]	Bending				Bend	_	Grain		<b></b>	Ovalized		Pressure/Forced
1	Centre No	ot Concer	ntric to (	D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		4 '	on Incomplete	<b>—</b>	Part Incorred	-	Weld
1	Crushed/Crimped.			ļ	Burrs		4	ions Incomplete/Uncl		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination		Mainte	nance		Part Moved		
	Heat Trea	t		_	Countersink		Mislabe	led	-	Positioned W	_	_
	Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
Ripples in Bend			Drill Holes	Offset								
Torque Waves in Extrusion			Drawing		Out of C	Calibration						

Outside Dimensions

DQA:

Date: .

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

•	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
	X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
		X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			Х		D2750-043	350 SKIDTUBE ASSEMBLY, LH
				Х	D2750-044	350 SKIDTUBE ASSEMBLY, RH
		L				
	1	1	1_1_	1	D2739	WEB
	- 8	8	-8_	8_	D2743	SPACER
	1	1	11	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1			Γ	D2750-1	SKIDTUBE WELDMENT, LH
		1			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBÉ WELDMENT, RH
	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	8	8			D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
	1	1	1	1	D3536-25	GASKET
À	3	3	3	3	D3537-1	WEARPAD
2	8	8	8	8	D3631-1	WASHER
Г	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	D3793-1	WEARSHOE
^ — <u>:</u>	1	1	1	1	D3793-3	WEARSHOE
/F)	1	1	1	1	D3794-1	GASKET
	1	1	1	1	D3794-3	GASKET
-				-		
F-	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
i	34	34	34	34	AN3C5A	BOLT
_	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
Δ	38	38	38	38	AN960C10L	WASHER
Æ	1	1	1	1	AN960C816L	WASHER
_	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21083C8	NUT
	4	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:** 

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

D

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 004

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 38 KSI

MINIMUM YIELD TENSILE STRENGTH = 38 KSI

SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

SHOLL

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WORK !! NO\_9020) MLJ

12-09-17

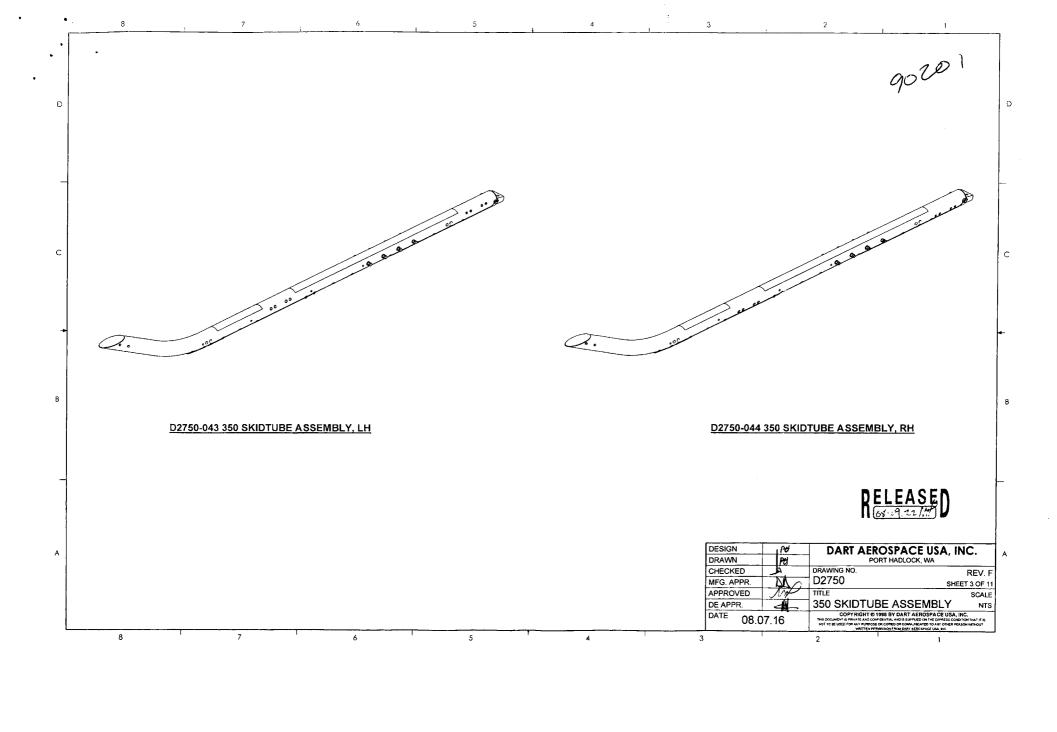


F	QTY (3) D3791- D3794- ADD D3 WEARS (8 PL), D3488- ADD NO	1791-1 (ZN C8-1 SHOE HÖLES U WEARSHOE HA	QTY (5) (ZN C8-1); D 0535-13-35 (ZN C8-1); D 0535-13-35 (ZN B8-1); D 0535-13-35 (ZN B8-1); D 0535-13-35 (ZN B8-1); D 0535-13-35 (ZN B8-1); D 0535-13-35 (ZN B8-1); WARE UPDATED (ZN C1-8, 9, 10, 11); (ZN A6-1);	РН	08.07.16			
E	REMOV NAS15	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE D17 (38) NAS1519413; REMOVE Q17 (10) CB 07.05.17 NAS15194B; REMOVE D2741, Q17 (2) AN960C816; REMOVE D17 (2) MS21033C8						
D	ADD HO	DLES AND SHAPORATE DEO 9	CERS FOR APICAL FLOATS; 133/9157	PH	06.01.05			
С	ADD D2	750-3/D2750-4;	INCORPORATE D2738 AND D2740	CP	98.11.18			
В	CHANG	E MS24694-S2	CP	98.09.01				
Α	NEW IS	SUE	DS	98.04.16				
REV.			DESCRIPTION	BY	DATE			
DESIGN P4,			DART AEROSPACE	USA	INC.			
CDAIA	NI.	QU	BUBT HADIOCK	10/0				

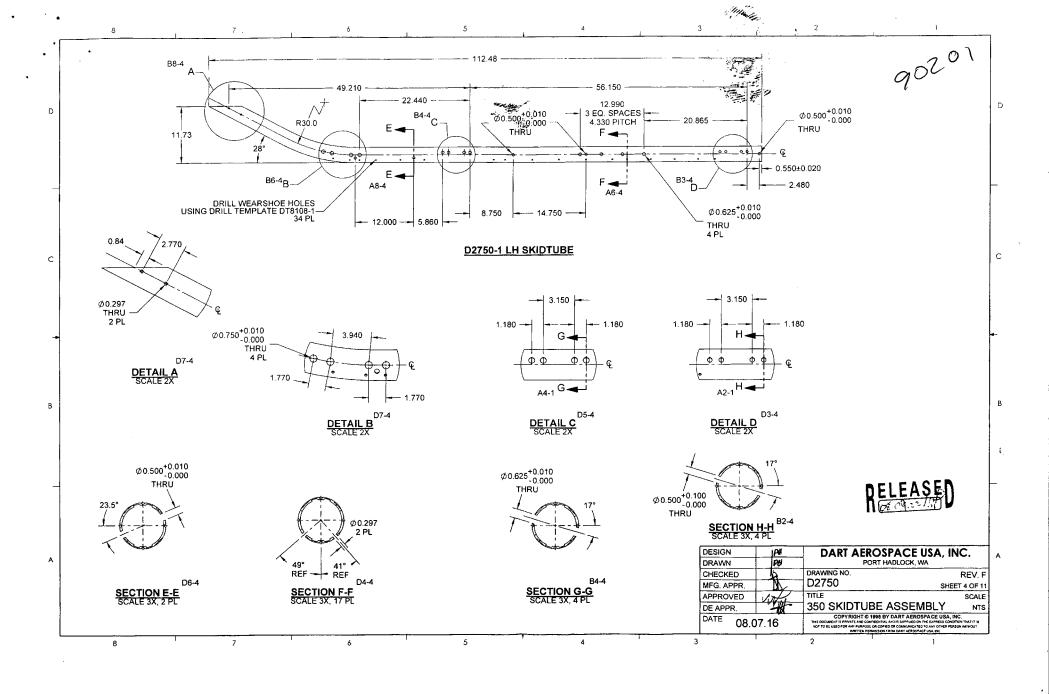
DESIGN	-	DAKI AEKOSPACE USA, INC.						
DRAWN	RES	PORT HADLOCK, WA						
CHECKED	116	DRAWING NO. REV. F						
MFG. APPR.	MO	D2750 SHEET 1 OF 1						
APPROVED	IM	TITLE SCALE						
DE APPR.		350 SKIDTUBE ASSEMBLY NTS						
DATE 08.0	7.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THE COCUMENT BEHAVE AND COMPRESS OF THE EXPRESS CONDITION THAT IF IT						

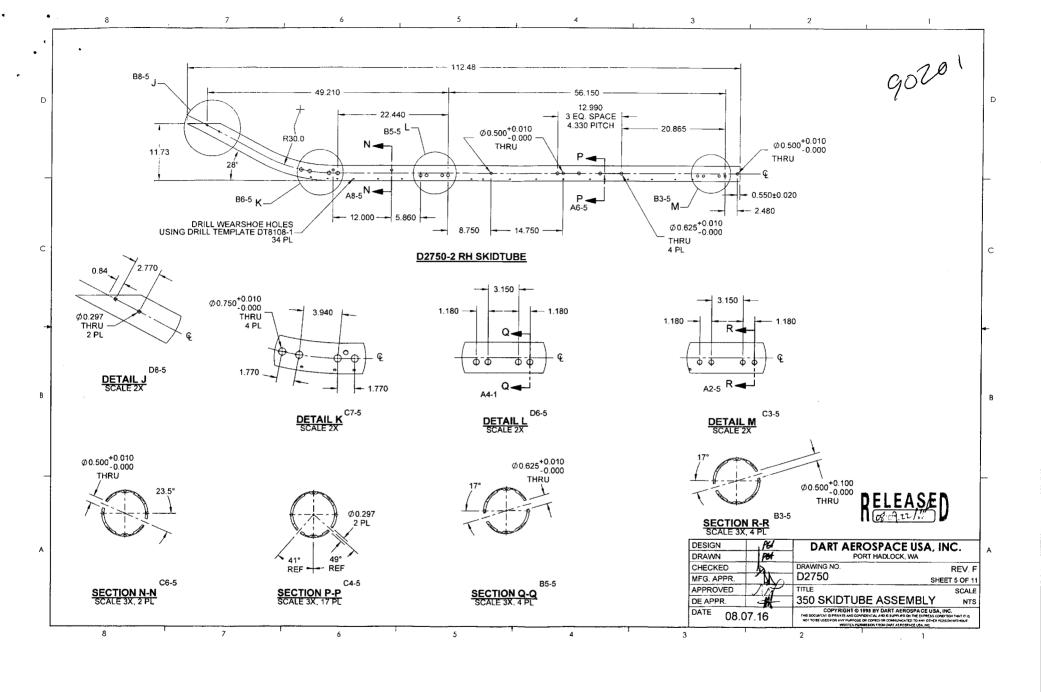
90201 В D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. D2750 CHECKED REV. F MFG. APPR. SHEET 2 OF 11 APPROVED SCALE 350 SKIDTUBE ASSEMBLY NT

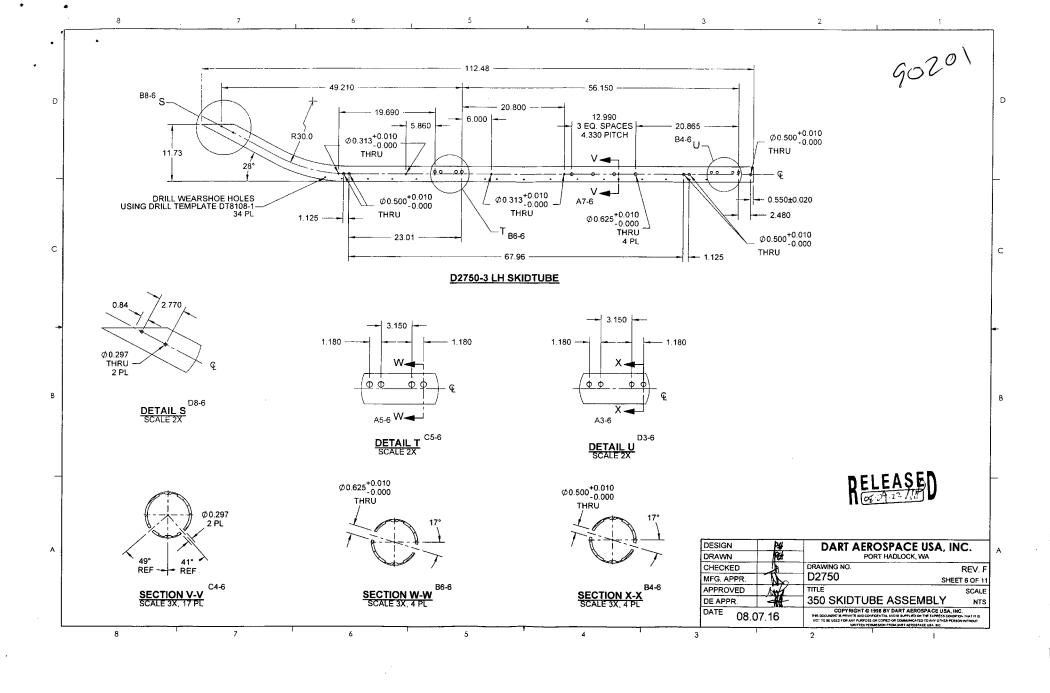
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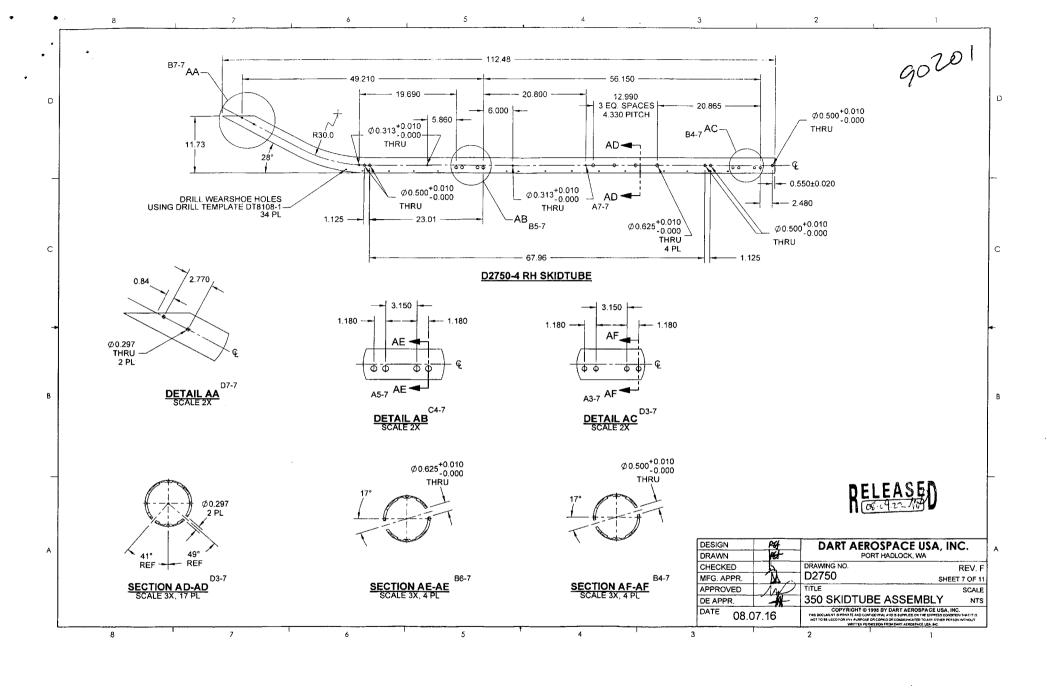


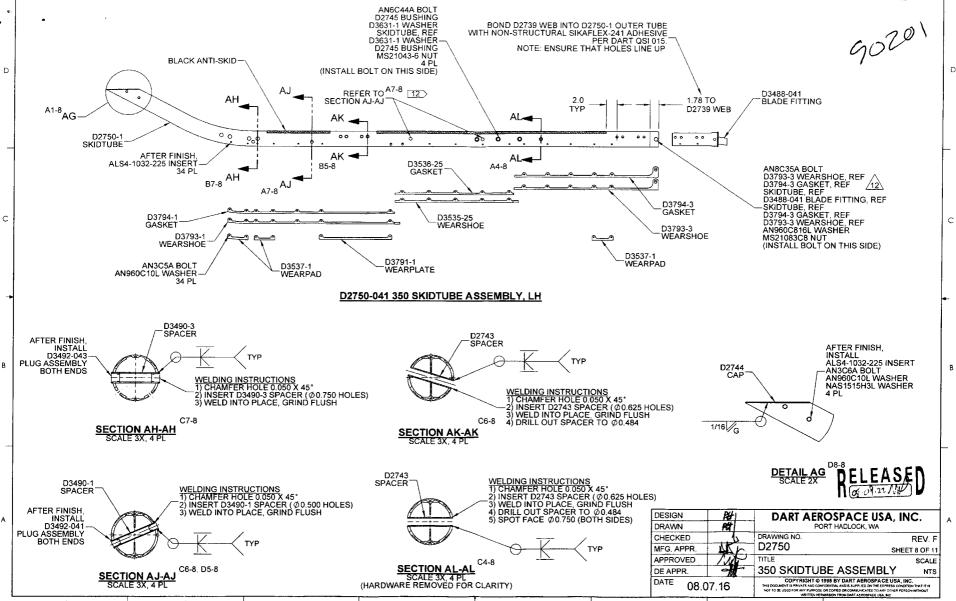
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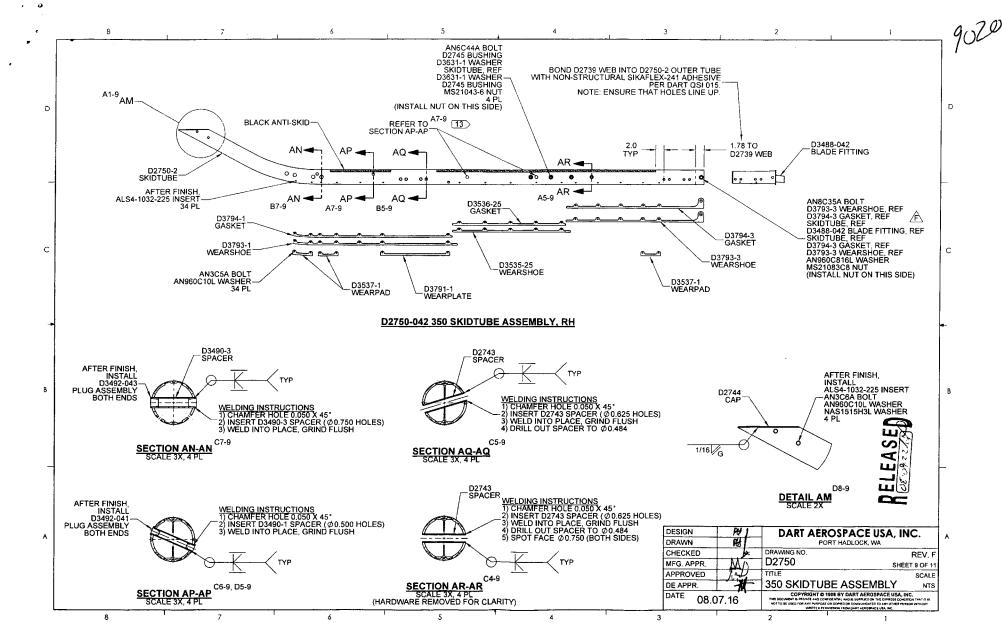


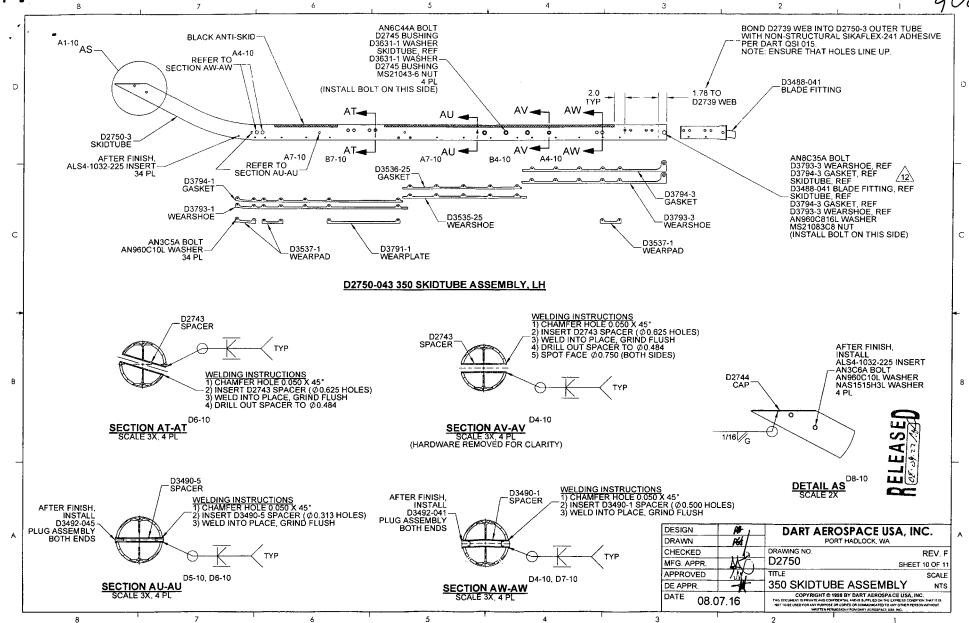




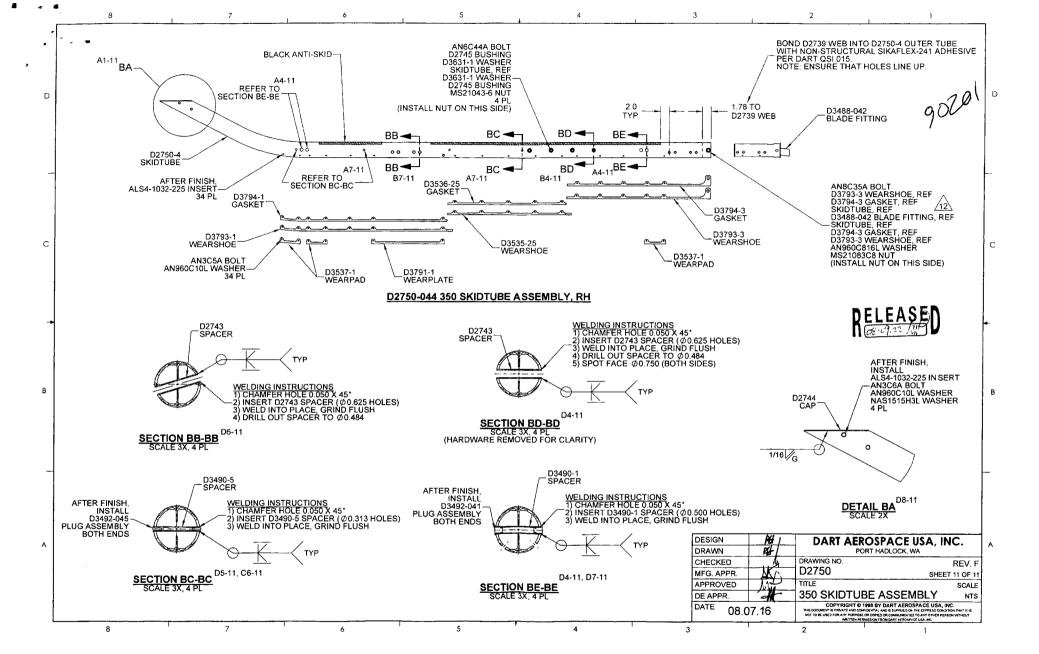








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NO. 300

## AWS D17.1.2001 QUALIFICATION TEST RECORD

Name:	Barday Elliott	
Job #:	87941	
Part #:	1350-636-011	
Description:	Seid	
Welding Pro	cess: Tig[-] Mig[]	
Base materie		
Current: AC	CLY DC[ ]	

## TEST REQUIREMENTS AND RESULTS

•	,
Visual:	pass[] fail[]
<b>Incomplete Penetration:</b>	pass[/] fail[]
Incomplete Fusion:	pass[] fail[]
Cracks:	pass[/ fail[]
Overlap (cold lap)	pass['] fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[] fail[]
Porosity (surface):	pass[/ fail[]
Coloration:	pass[] fail[]
Burn through:	pass[ ] fail[ ]

Qualifier David Action Date of Test Coupon 12.07.26

Welder Box Coupon 12-07-24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

PMC Manager Community

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